

Work Order ID 116349

April-11-14 12:46:49 PM

116349

Page 1

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 4/11/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/14/14 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	C								
D4020	A								

100

Weld per dwg A/R S.S. rod Batch: 4123823 0.00

Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

1x DAS 43 14-4-15
9-89

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

① 14-04-15 DAS 9
9-89

Work Order ID 116349

April-11-14 12:46:49 PM

116349

Page 2

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 4/11/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				①	14-04-15		DAS 9 9-89
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per OSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: 10:00 Oven Temperature: 320° Finish Time: 10:30								
140	Wing Walk as per dwg OSI005 4.4 Batch 1112862039								
140									
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***								

1 ① 14-4-15 DAS 34 9-89
 1x of all 14/04/16

Work Order ID 116349

116349

Page 3

April-11-14 12:46:49 PM

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 4/11/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/14/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/O</u> Memo	0.00 0.00							
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

ML5 1404-22
 ML5 1404-22

Picklist Print

April-11-14 12:46:47 PM

Work Order ID: 116349

116349

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/11/14

Required Date: 4/14/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS
PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG
REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3914-1		Manufactured	No			100	Each	6.0000	2	2			
D3914-1													
Rib													

Location	Loc Qty	Loc Code	DAS
WA004	6		43
105283	6		9-89

D3914-7		Manufactured	No			100	Each	8.0000	2	2			
D3914-7													
Rib													

Location	Loc Qty	Loc Code	DAS
WA004	8		43
106115	8		9-89

D4018-5		Manufactured	No			100	Each	57.0000	9	9			
D4018-5													
Rib													

Location	Loc Qty	Loc Code	DAS
WA004	57		43
103494	18		9-89
106726	3		
110935	36		

Picklist Print

April-11-14 12:46:48 PM

Page 2

Work Order ID: 116349

116349

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/11/14

Required Date: 4/14/14

Start Qty: 1.00

Required Qty: 1.00

D4035-043	Manufactured	No	100	Each	8.0000	2	2		DAS
D4035-043									43
Lid Rib Assembly, Aft (350 Basket)								**	B 109434 → 2x 14-4-11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	8	
109434	8	

D2581	Manufactured	No	100	Each	176.0000	2	2		DAS
D2581									43
Mounting Bracket								**	B 103683 → 2x 14-4-11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	176	
102265	94	
103683	44	
105886	38	

D2728-3	Manufactured	Yes	140	Each	0.0000	0	0		
D2728-3								**	

Dart Logo Label Large

D4016-3	Manufactured	No	100	Each	28.0000	3	3		DAS
D4016-3									43
Hinge Half, Lid								**	B 106882 → 3x 14-4-11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	28	
106882	12	
115144	16	

D4020-5	Manufactured	No	100	Each	6.0000	1	1		DAS
D4020-5									43
Mesh (350 Basket Long, Lid)								**	B 106803 14-4-11

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA004	6	
106803	6	

Picklist Print

April-11-14 12:46:48 PM

Page 3

Work Order ID: 116349

116349

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/11/14

Required Date: 4/14/14

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured

No

100

Each

12.0000

1

1

DAS

D4021-3

B 101346

43

9-89

14-4-11

Data Plate

Location

Loc Qty

Loc Code

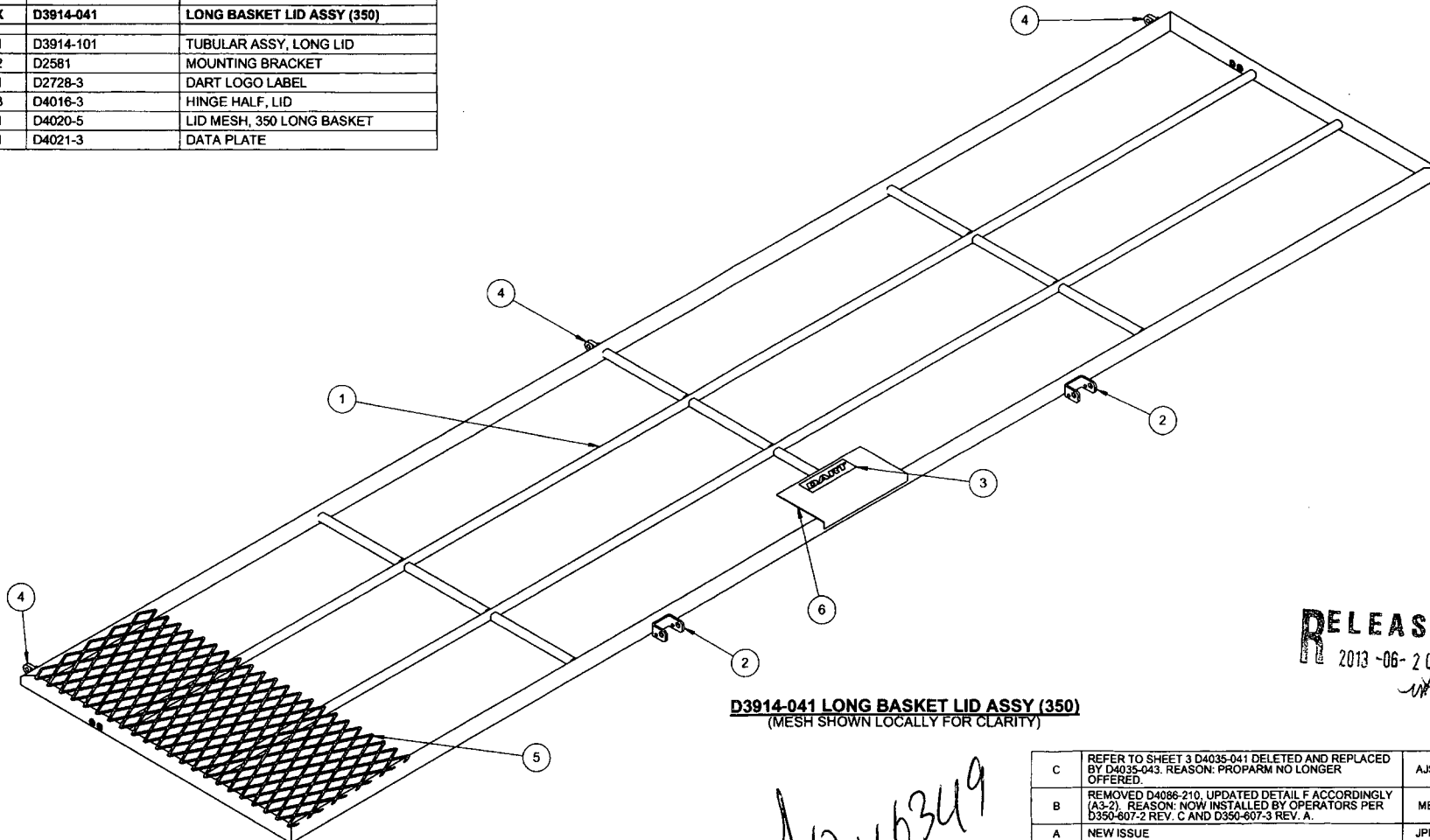
WA004

12

101346

12

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE

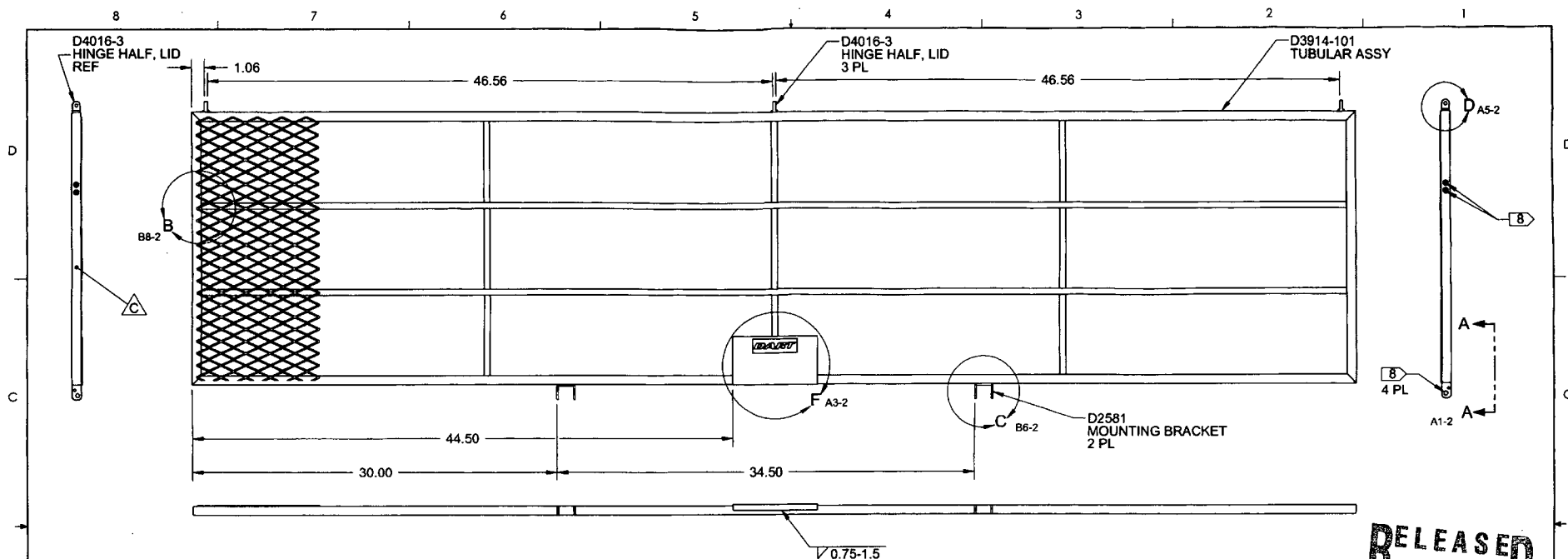


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

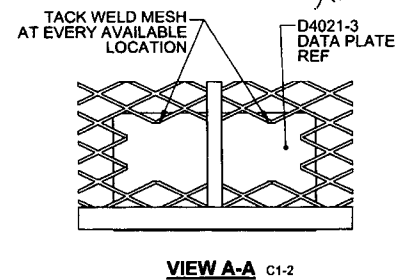
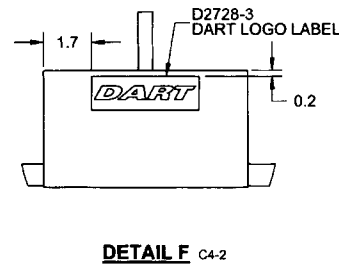
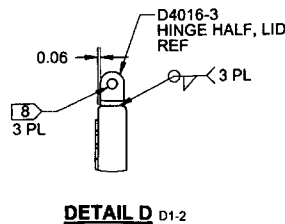
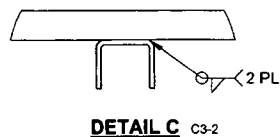
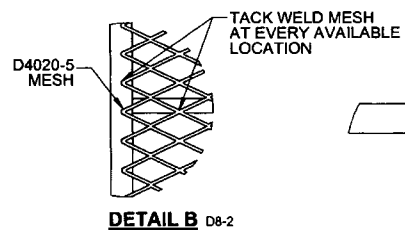
RELEASED
2013-06-20

W6116349

C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROFORM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3914	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET LID ASSY (350)	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



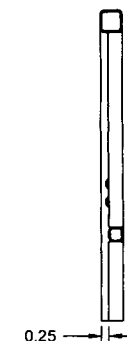
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

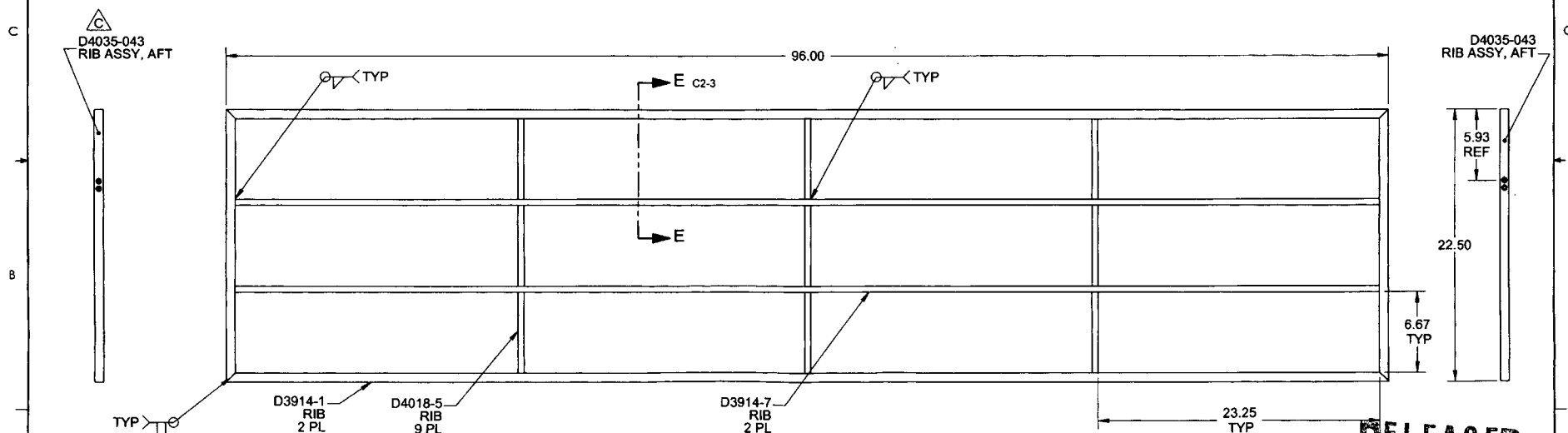
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	AJS	D3914	SHEET 2 OF 4
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	LONG BASKET LID ASSY (350)	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2013-06-20

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3914-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D3914	REV. C
MFG. APPR.		SHEET 3 OF 4	
APPROVED		TITLE LONG BASKET LID ASSY (350)	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	13.03.13	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-06-20

